

Work Order ID 72129

Page 1

Tuesday, July 19, 2011 12:41:45 PM

Item ID: D3502-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1/07/19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3502	Rev B

100



BAND SAW

Bandsaw

Memo

0.00

0.00

AK/JK 1/08/19 14 0

Jeaspa Bandsaw

Cut blank 3.475 " long 1 BLANK MAKES 2 PARTS

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

0.00

JK/B-A 1/08/19

HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: A & Dwg D3502 Rev: B 2-Deburr
per dwg D3502

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

0.00

AK/JK 1/08/19

Quality Control

W/O: 72129

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: 11/1 Fault Category: Machinery NCR: Yes No DQA: A Date: 11.09.08
 11.08.20 Resolution: ~~Review~~ use as in Rccopable Disposition: ~~Review~~ use as in QA: N/C Closed: QA Date: 11/09/08

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.24	110	Small amount of mat'l removed from one CORNER. ≈ 0.030. R.C. L0A operator error	CP 11.08.24 Q51042	Acceptable. No effect on strength. Buff edge to make it flat.	CP 11.08.24	11.08.24 CP 11.8.25 Q51042 11.09.08	CP 11.08.24 S	

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

SL 11-08-26

14

Ø

140



Small Fab

Small Fab

0.00

0.00

Small Fab

Memo

Mark hole position using DT9430 Drill as per Dwg D3502.

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

M117745

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

14X 5 m-11/08/31

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

14 BL 11-8-31.

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: ST 63

0.00

Memo

0.00


 14X SP 1-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

19/6/11
MFT 11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, July 19, 2011 12:41:51 PM

Work Order ID: 72129



Parent Item: D3502-1



Parent Item Name: Support

Start Date: 7/19/2011

Required Date: 8/25/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-07-06 JLM
IPP Rev:B Add tooling hole 07-03-28
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	26.3100	0.289	3.650526			

6061-T6 Bar 1.00 x 4.00



Location	Loc Qty	Loc Code
MAT004	26.31	
107221	22.23	.593
114352	2.58	
116808	1.5	1.5

JK - 11/08/11

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72129
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <i>J.K./mgf</i>	Audited by: <i>J.K.</i>	Prototype Approval: N/A
Date: 11/08/12	Date: 11-08-26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.03.29	Dwg Rev. updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

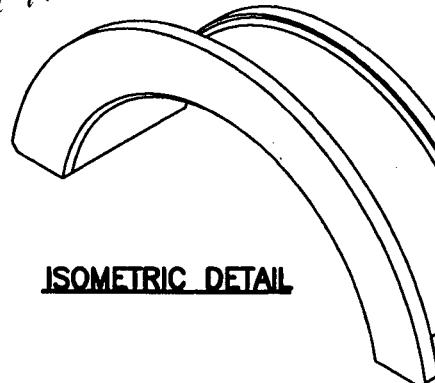
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SHOP COPY
RETURN TO
ENGINEER
UNCONTROLL
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

DART

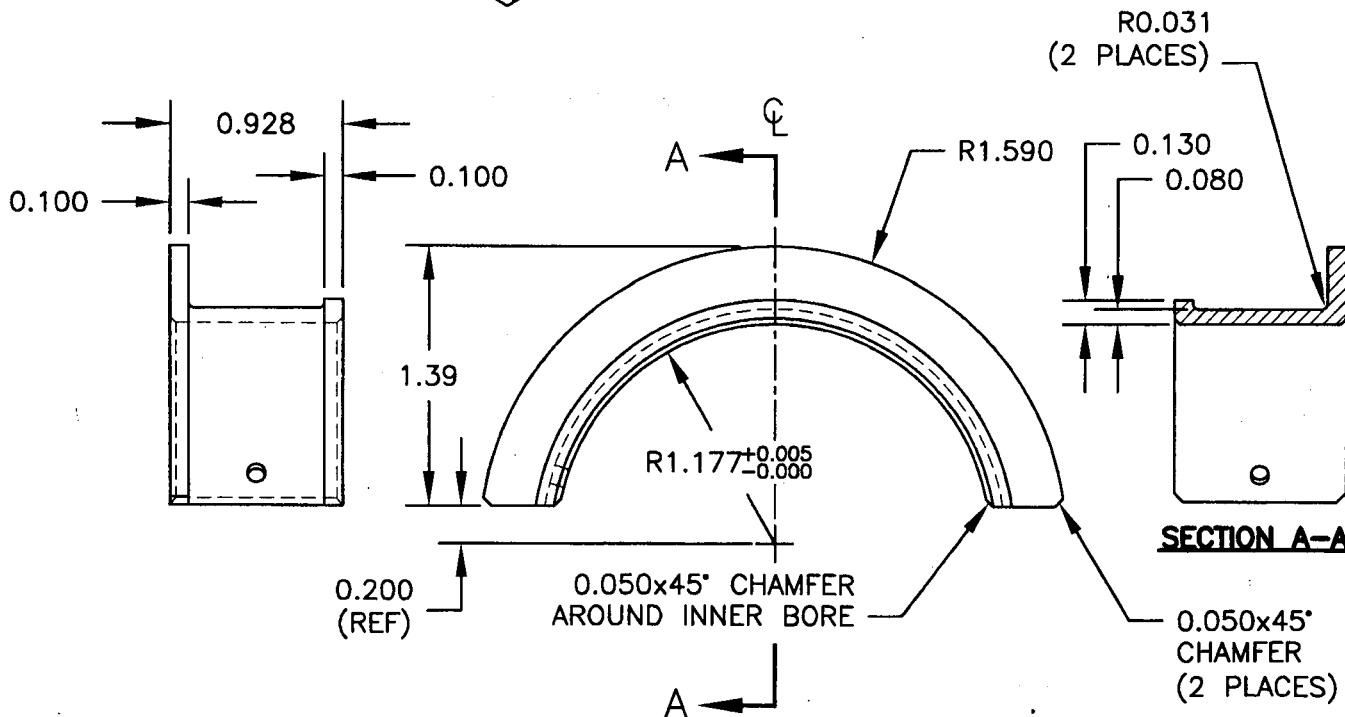
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3502
DATE		REV. B SHEET 1 OF 1
06.10.31		TITLE SCALE SUPPORT 1:1
A	06.04.18	NEW ISSUE
B	06.10.31	ADD TOOLING HOLE FOR FINISHING



ISOMETRIC DETAIL

OPTIONAL $\phi 0.098$ (DRILL #40)
TOOLING HOLE, CENTERED ON PART
(ONE PLACE ONLY)

RELEASED
06.12.06 CP
PER ECN 985



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

W/O:

WORK ORDER CHANGES

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